

Work Order ID 110146

December-17-13 9:16:12 AM

D 2876
B 110146

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Item ID: D2876

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Saddle Spacer

Start Date: 12/17/13 Start Qty: 30.00

30

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-12-18

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2876	Rev B
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2876

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

30 0 Jm14-02-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

30 0 Jm14-02-12

6061 1100

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Item ID: D2876 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle Spacer
Start Date: 12/17/13 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 12/17/13 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 DAS 27 14/2/12				30 Cen			
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				30	7/6/142-12		
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo	0.00 DAS 27 3-39 14/2/13				30 Cen			

Picklist Print

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Work Order ID: 110146

Parent Item: D2876

Parent Item Name: Saddle Spacer

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 30.00

Required Qty: 30.00

Comments: Esr Rev:B00.05.19Added inspect level 8EC
IPP Rev:C Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100 6061-T6 .100 Sheet		Purchased	No			100	sf	10.0000	0.0516	1.629474 2.0		Jm 14-02-12	

Location

Loc Qty

Loc Code

MAT021

10

124193

10

124193

7

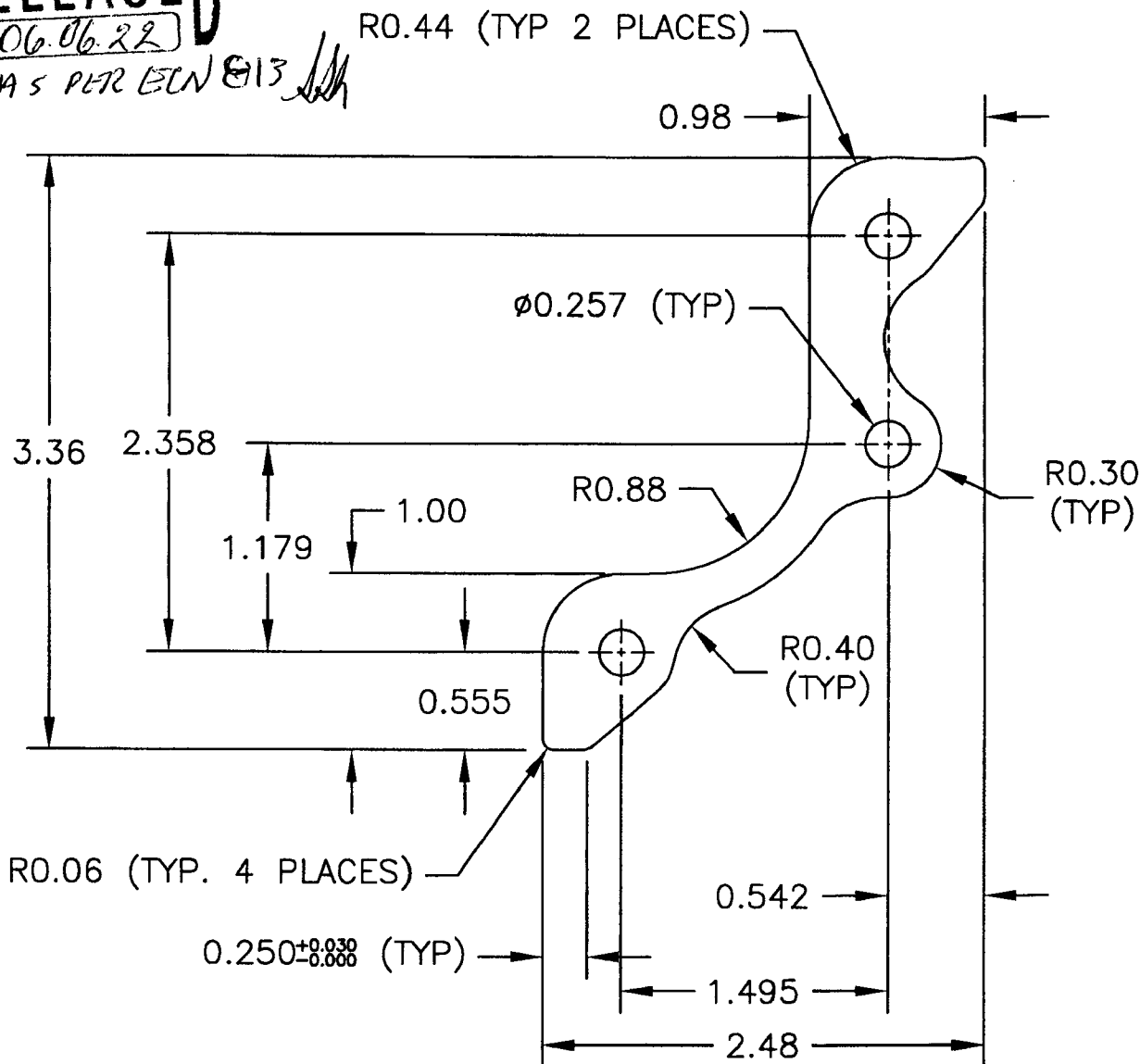
FACE
21



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED
06.06.22

AS PER ECN 813 *[Signature]*



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

110146 MJS
13-12-18

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